

5/24

Split

DART AEROSPACE LTD		Work Order:	23460 #
Description: Gas Spring		Part Number:	D2807
Dwg: D2807 Rev. C		Qty:	80 24
Page 1 of 1			

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.07.19	60
2	PG	Issue P/O: <u>2008151</u> Order as per Dwg D2807 Possible supplier: ArvinMeritor Motion Control Systems Material release note is required	U	05.08.02	60
3	RG	Receive and Inspect for transit damage Ensure the material release note is attached	OL	05/07/19	59 24
4	QC6	Inspect dimensions as per Dwg D2807	SB	05/08/16	24
5	GA	Install lugs and crimp as per Dwg D2807 Pick: Qty Part Number Description Batch 2 D2807-3 Lug <u>B23915</u>	SB	05/08/16	24
6	QC5	Inspect work to Step 5	2	05-08-16	24
7	ST	Identify and Stock	2	05-08-16	24
8	AC	Cost / part: <u>33.48</u>	SUC	05-08-17	24
9	DC	Close W/O <u>51.67</u> Inspect Level 21	LD	05-08-17	24

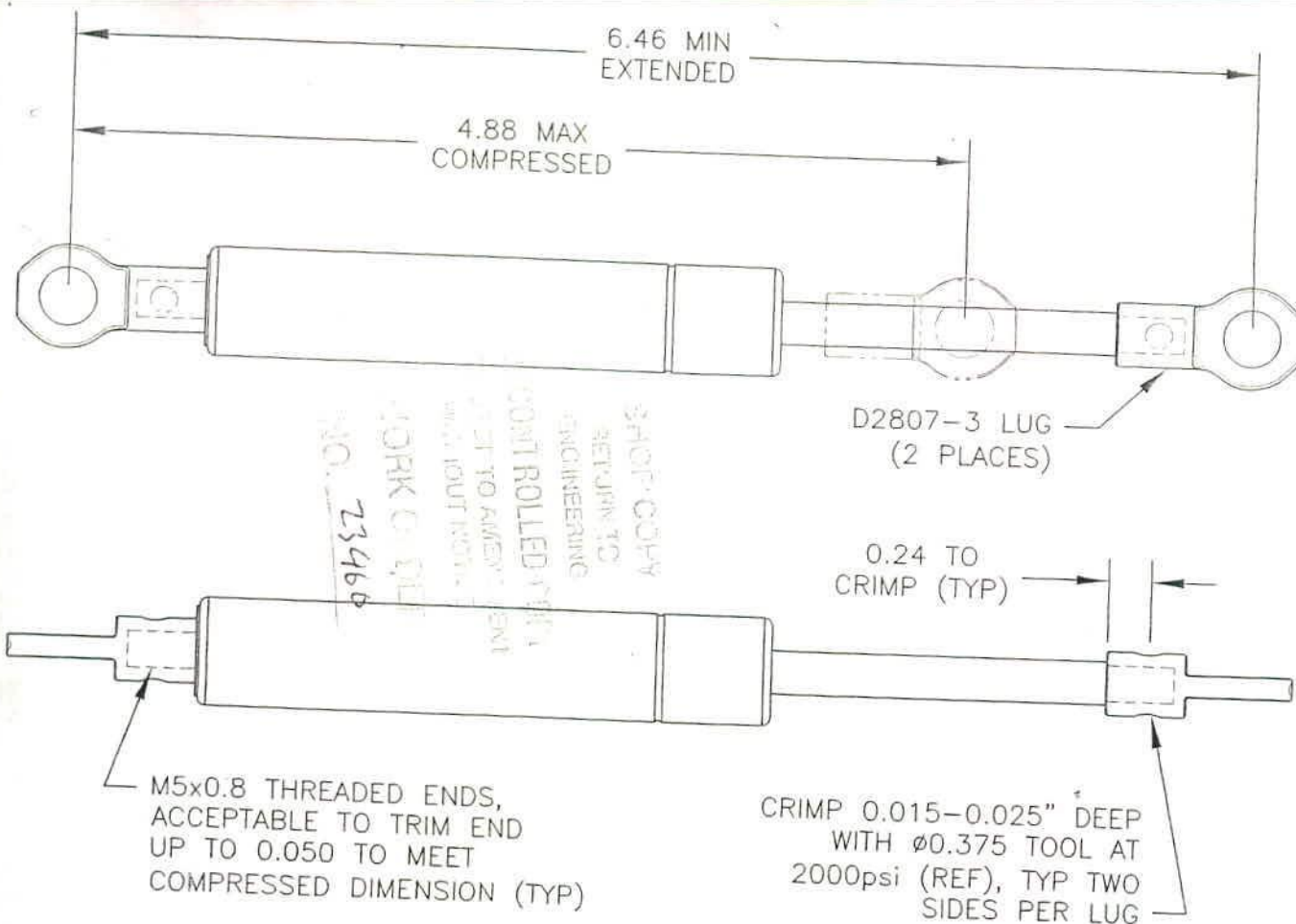
Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Added step 6	EC	
C	05.04.28	Reformat; Added Step 6 & 7	KJ/JLM	
D	05.06.21	Removed painting; Changed supplier	KJ/JLM	<i>[Signature]</i>

RELEASED
21/5.06.21

DART

RELEASED
RECEIVED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
05.05.25	05.05.25	D2807
DATE	TITLE	SCALE
05.05.25	GAS SPRING	1:1
A	00.11.03	NEW ISSUE
B	05.03.16	ADD FINISH
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG





D2807 GAS SPRING

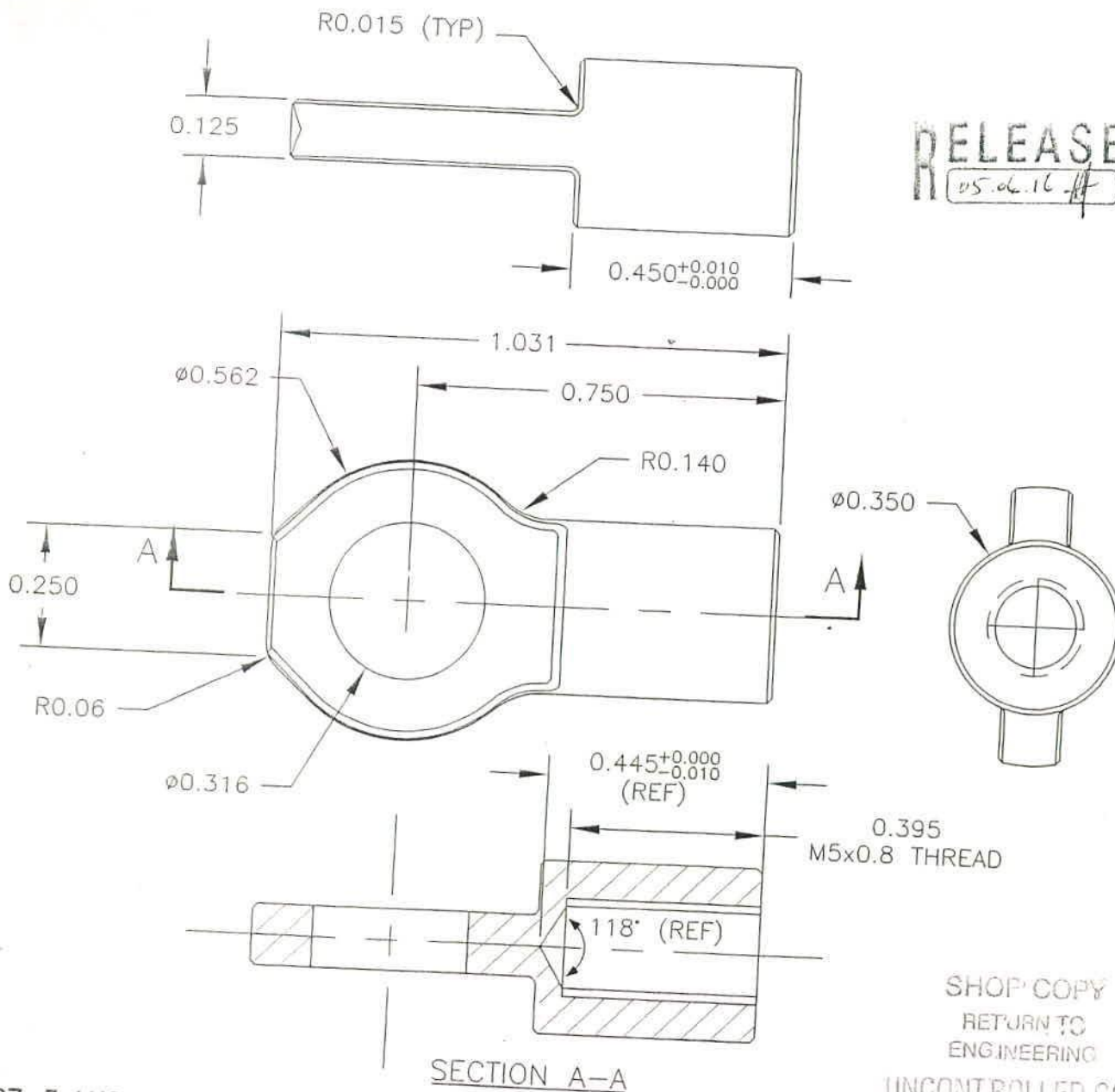
- 1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2807	REV. C
DATE 05.05.25		TITLE GAS SPRING	SHEET 2 OF 2
			SCALE 3:1



RELEASED
05.06.16

2807-3 LUG

- MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- FINISH: NONE
- BREAK ALL SHARP EDGES 0.010 TO 0.015
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 13460

PAID PROFORMA — [

CHECK CUSTOMER HAS PAID
CARRIAGE BEFORE SHIPPING

17999

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CUSTOMER REF. No.

2008151

V.A.T. REGISTRATION No. GB 738 8577 71

Cam 001

15 New Star Road, Leicester, LE4 9JD, UK
Main Fax: +44 (0)116 274 3620
E-mail - info.amcl@arvinmeritor.com
Website: www.camloc.com

TNT
GE50169785WW

Certified that the whole of the supplies detailed hereon have been inspected and tested and unless otherwise stated conform in all respects with the contract/purchase order requirements.

SIGNED

POSITION